

Work Order ID 82515

82515

Page 1

Monday, April 02, 2012 10:19:24 AM

Item ID: D4150-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Attachment Arm Assembly
 Start Date: 4/2/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/2/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *MF* Date: *12-04-02* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4150	B

100 0.00

100

Small Fab Memo 0.00
 Small Fab 1- Assemble as per dwg

EP 12/04/02 ①

110 QC5- Inspect part completeness to step on W/O 0.00

110

QC Memo 0.00
 Quality Control

Sc 12/04/02

120 Identify as per dwg & Stock Location: 0.00

120

Packaging Memo 0.00
 Packaging

12/04/02 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82515***82515***

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Item ID: D4150-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Attachment Arm Assembly

Start Date: 4/2/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/2/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MCS 12/04/02

MCS 12/04/02

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Picklist Print

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Page 1

Work Order ID: 82515

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly

Start Date: 4/2/2012

Required Date: 4/2/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C13A Bolt		Purchased	No			100	Each	59.0000	2	2		4/12/04/02	
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						ST351		59					
						117366		9		2			
						120630		50					
D4150-1 Arm		Manufactured	No			100	Each	0.0000	1	1		4/12/04/02	
D4150-3 Arm Plate		Manufactured	No			100	Each	36.0000	2	2		4/12/04/02	
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						ST133		36					
						80739		2		2			
						81465		14					
						81907		20					
MS21043-3 Nut		Purchased	No			100	Each	597.0000	2	2		4/12/04/02	
						<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>				
						FG		72					
						103691		72					
						GA		254					
						120693		254		2			
						ST301		271					
						118077		2					
						118614		219					
						118686		30					
						119758		20					

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Work Order ID: 82515

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly

Start Date: 4/2/2012

Required Date: 4/2/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

100

Each

1,206.0000

4

4

Washer

Location

Loc Qty

Loc Code

ST297

1206

118354

379

119736

196

120648

631

4

JS 4/2/04/02

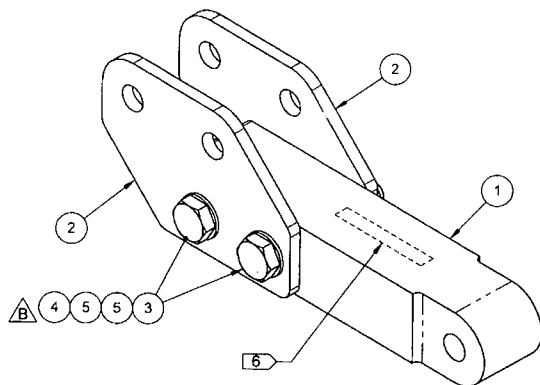
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D4150-041 ATTACHMENT ARM ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.82 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER

RELEASED
2010-07-16
MB

REV. B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C13A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2, C7-2, B4-3 & B5-3). REASON: SEE TR-D350-807-2 REV. B.	MB	10.07.08
REV. A	NEW ISSUE	MB	10.06.18
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	DRAWING NO. D4150		
CHECKED	REV. B		
MFG. APPR.	SHEET 1 OF 3		
APPROVED	TITLE ATTACHMENT ARM ASSY		
DE APPR.	SCALE NTS		
DATE	10.07.08	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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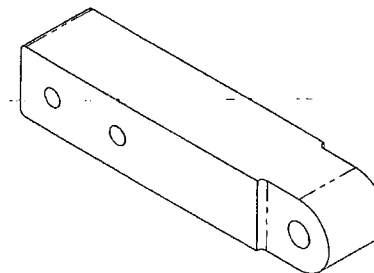
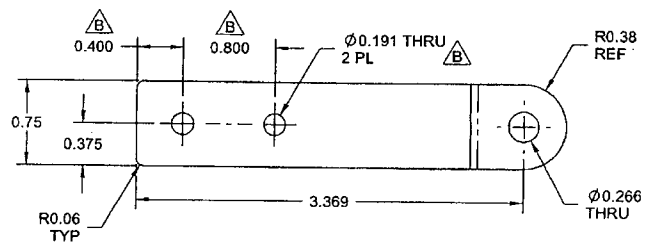
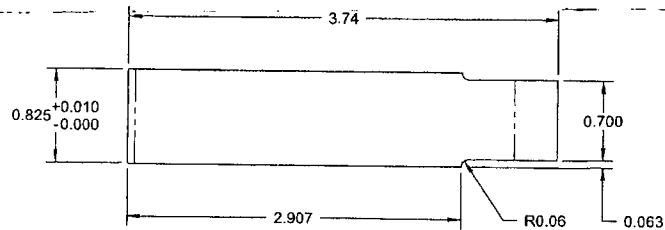
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D4150-1 ARM

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

82515

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D4150 SHEET 2 OF 3
APPROVED		TITLE SCALE
DE APPR.		ATTACHMENT ARM ASSY NTS
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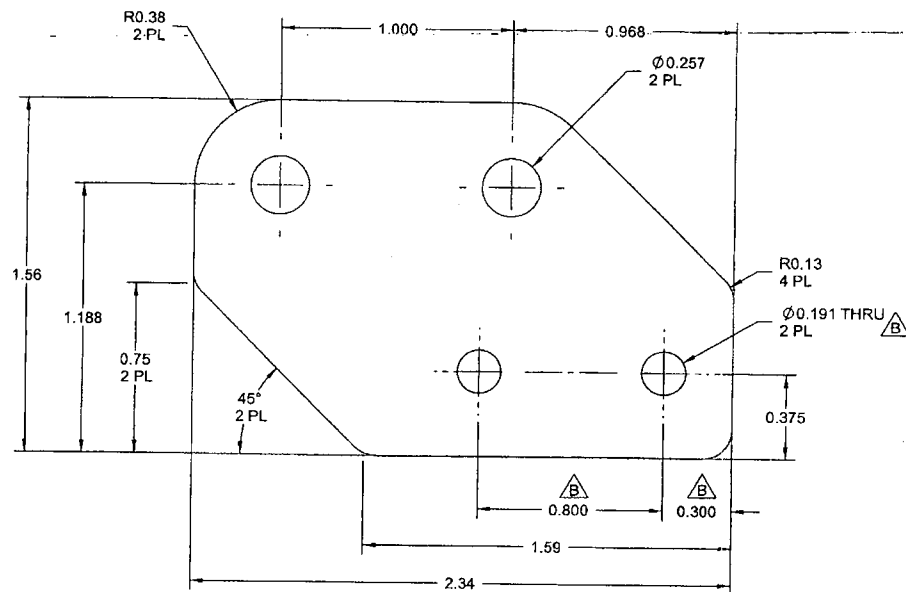
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



D4150-3 ARM PLATE

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

82518

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
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